

Work Order ID 81427

March-14-12 8:29:17 AM

81427

Page 1

Item ID: D3805-045
 Revision ID:
 Item Name: Wearplate Assembly Aft Low Gear
 Start Date: 3/14/12 Start Qty: 8.00
 Required Date: 3/20/12 Req'd Qty: 8.00
 Reference:


Accept

N9000040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

8
8

Approvals: Process Plan: 
 QC:

Date:
 Date:

Tooling:
 SPC (Y/N):

Date:
 Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/
 Work Center ID Operation
 Description

Set Up/
 Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
 Code Qty Qty Number Stamp

Draw Nbr Revision Nbr

D3805 B
 100

0.00

100
 Large Fab
 Large Fab

Memo

0.00

1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805
 2059 B Hardcoat Welding Rod
 BATCH#: M122030

2-weld D3806-5 to D3805-5 together as per dwg D3805
 304 S.S. Welding Rod
 BATCH#: M120013

3-Transfer drill holes in bar

CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT

110 QC9- Inspect visual per QSI004- Fusion Welds

0.00

110
 QC
 Quality Control

Memo

0.00



MAL

12/07/18



12.7.18



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Item ID: D3805-045
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 Start Date: 3/14/12 Start Qty: 8.00
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 Reference:

Accept

N9000040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 11:15 OVEN TEMPERATURE: 320 °F FINISH TIME: 11:45	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

DAS 16

17/07/12

20

10X

M-F
12/07/19

M121279

10

12/07/19

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Page 3

Item ID: D3805-045
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 Start Date: 3/14/12 Start Qty: 8.00
 Required Date: 3/20/12 Req'd Qty: 8.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Bond D3807-5 gasket to inner surface of wearplate using a thin layer of 3m
 1300/1300L scotch grip adhesive as per dwg
 BATCH: m/22 306

10 ϕ

Ae
 12-07-20

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DAS
 16
 8-8 12/07/20

(410)

170

Identify as per dwg & Stock Location: FP-1

0.00

170

Packaging

Memo

0.00

Packaging

10 ϕ (20) 12/07/23

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Page 4

Item ID: D3805-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly Aft. Low Gear

Start Date: 3/14/12 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/20/12 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/17/24
MCS 12/07/23

Picklist Print

March-14-12 8:29:17 AM

Page 1

Work Order ID: 81427

Parent Item: D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 3/14/12

Required Date: 3/20/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg
DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3805-5

Plate

Manufactured

No

100

Each

38.0000

1

8

B 79622 (X4)

B 78128 (X2)

B 80439 (X4)

~~B 8043~~

Location

Loc Qty

Loc Code

WA

34

79568

20

79622

14

WA030

4

75676

2

78128

2

(X10)

MAL

12/07/18

D3806-5

Bar

Manufactured

No

100

Each

54.0000

1

8

B 80442 (X10)

Location

Loc Qty

Loc Code

WA

50

79570

30

80442

20

WA030

4

46781

2

75941

2

(X10)

MAL

12/07/18

D3807-5

Gasket

Manufactured

No

150

Each

75.0000

1

8

Location

Loc Qty

Loc Code

GA

75

74944

1

78132

3

79572

37

79626

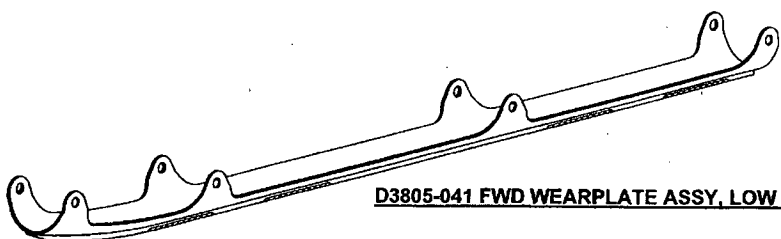
34

Ac

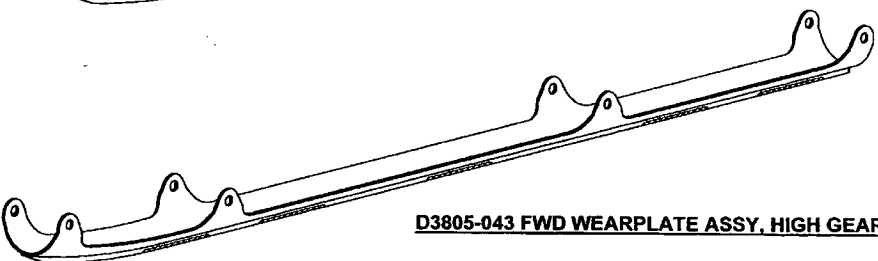
12.07.18

(10)

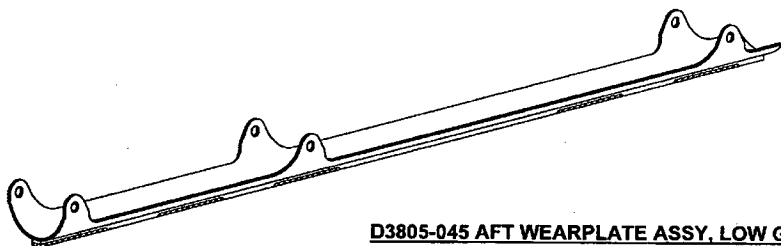
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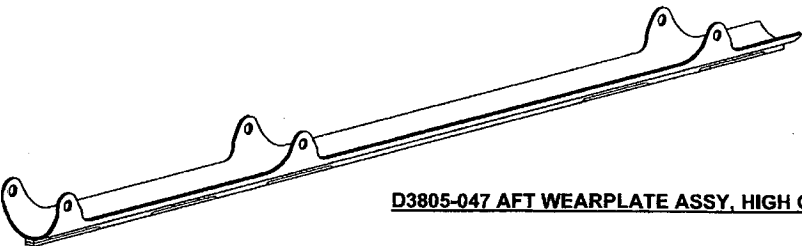
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

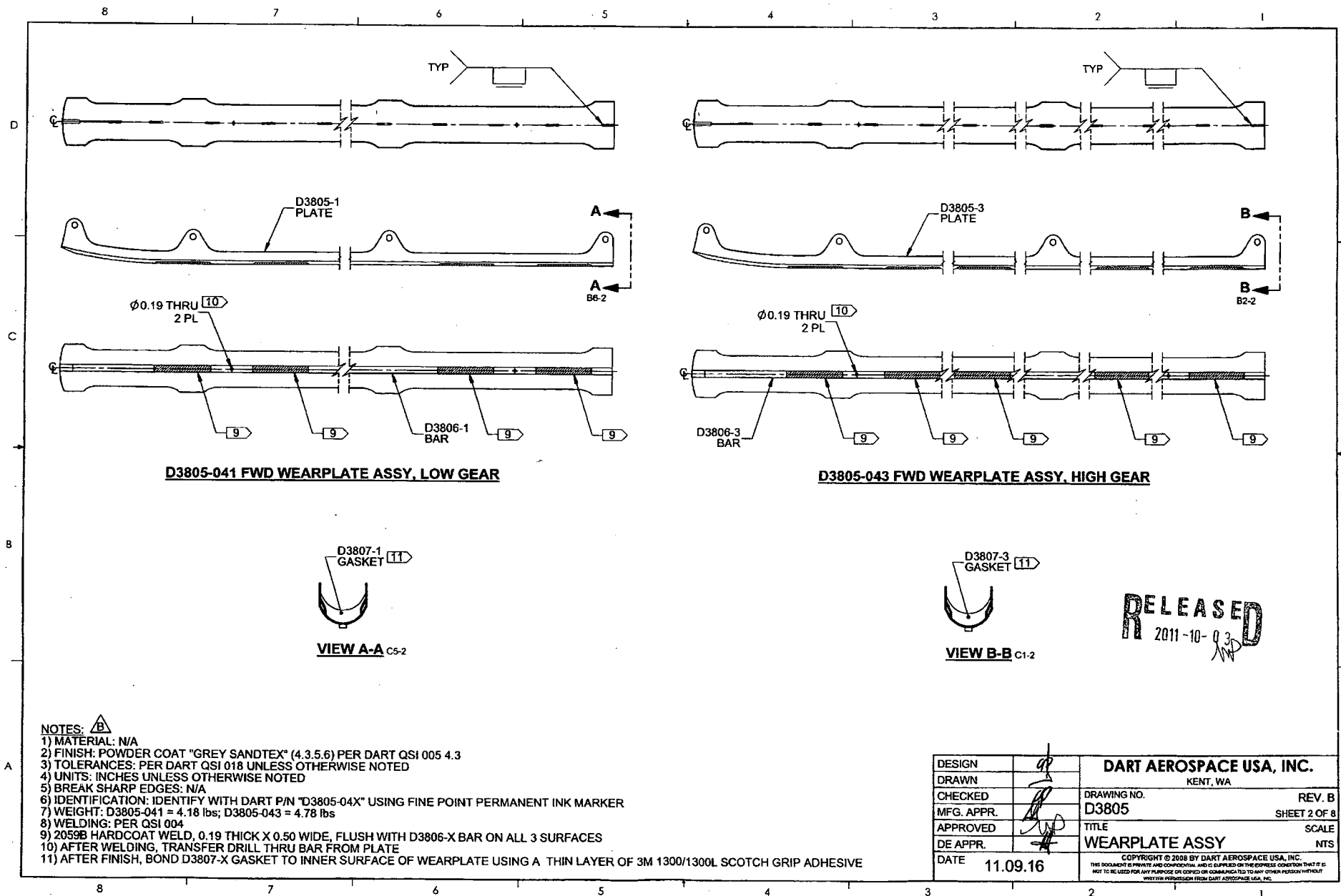
8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

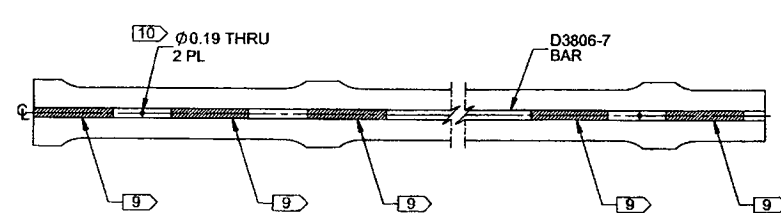
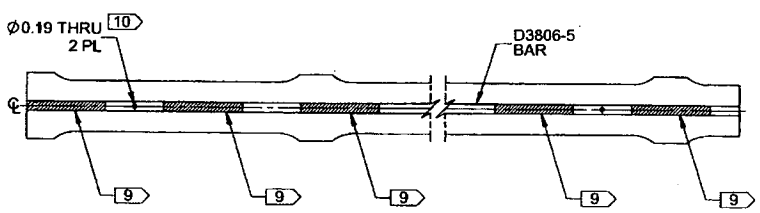
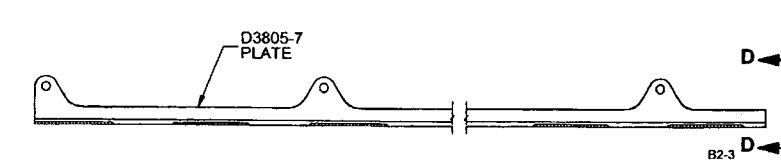
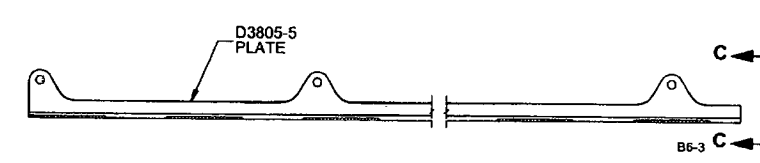
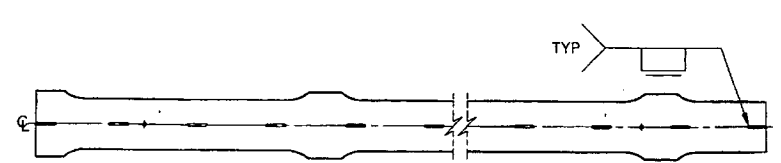
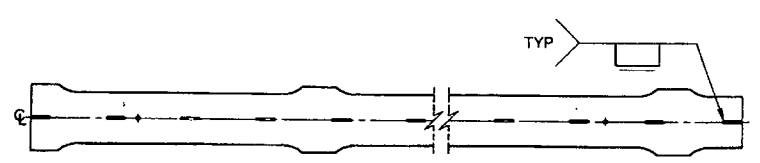
W/081427

RELEASED
2011-10-03

B	REVISED D3805-1F1-3F TO EASE MANUFACTURABILITY (ADDED CUTOFF AT FWD END OF PLATE PER PART11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MB	11.09.16
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC.		KENT, WA	
DRAWN	DRAWING NO. D3805		REV. B	
CHECKED	TITLE WEARPLATE ASSY		SHEET 1 OF 8	
MFG. APPR.	SCALE		NTS	
APPROVED	DATE 11.09.16		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

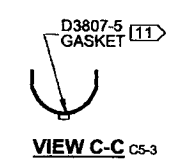


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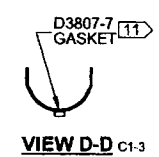


D3805-045 AFT WEARPLATE ASSY.

D3805-047 AFT WEARPLATE ASSY.



VIEW C-C C5-3



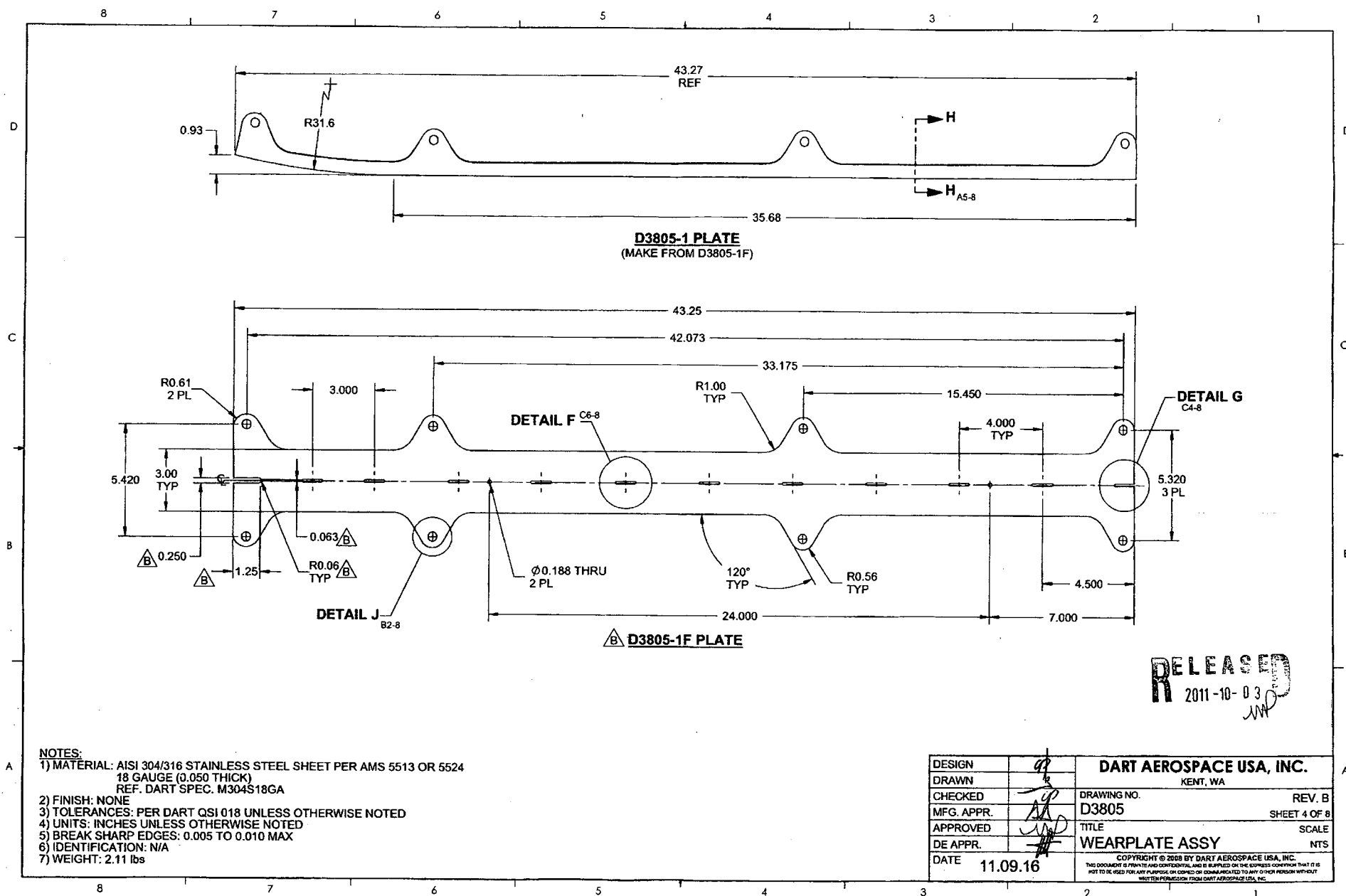
VIEW D-D C1-3

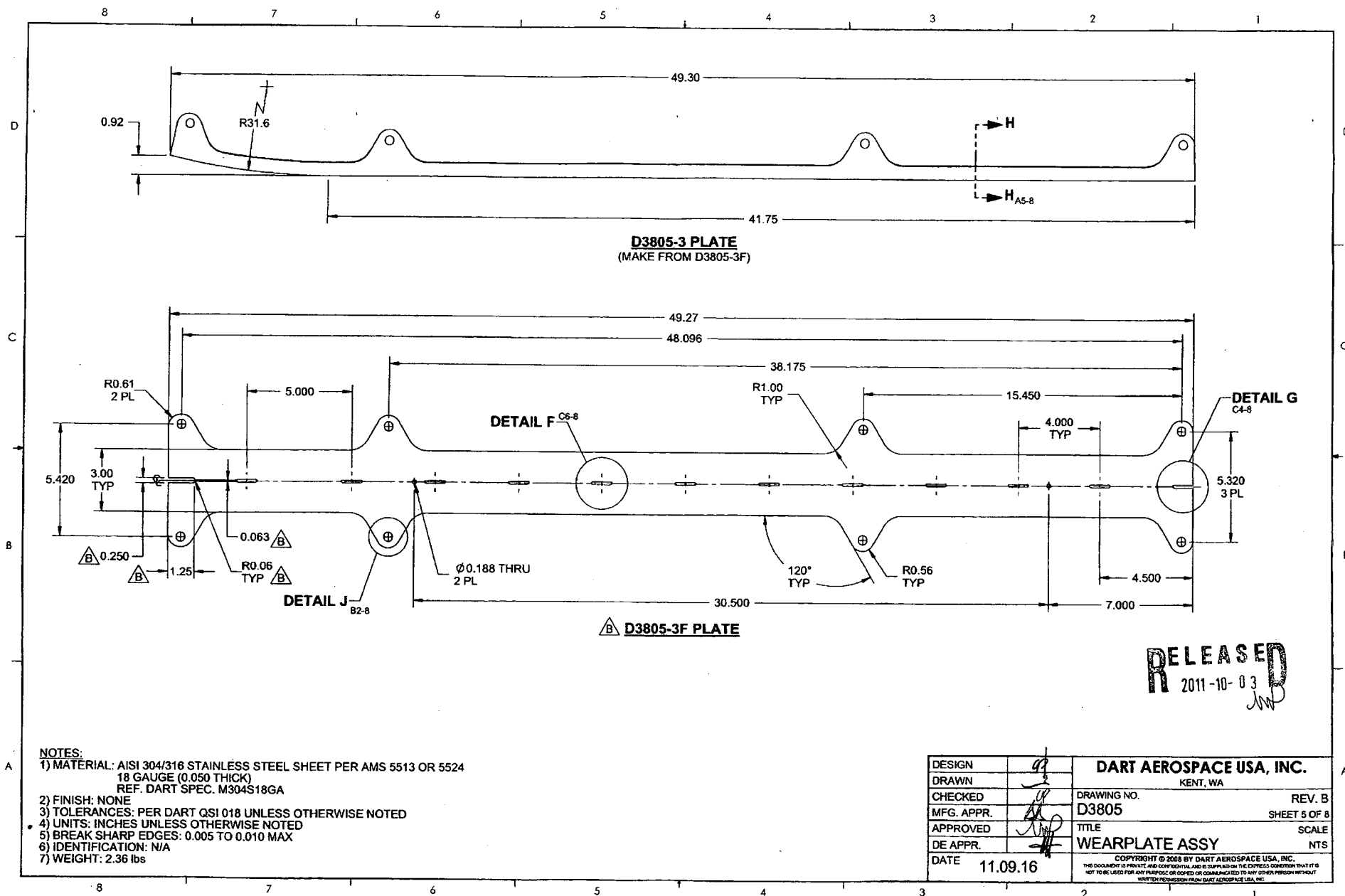
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2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

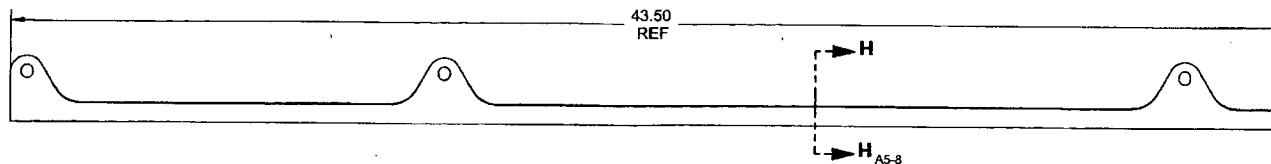
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MFG. APPR.		D3805	SHEET 3 OF 8
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DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

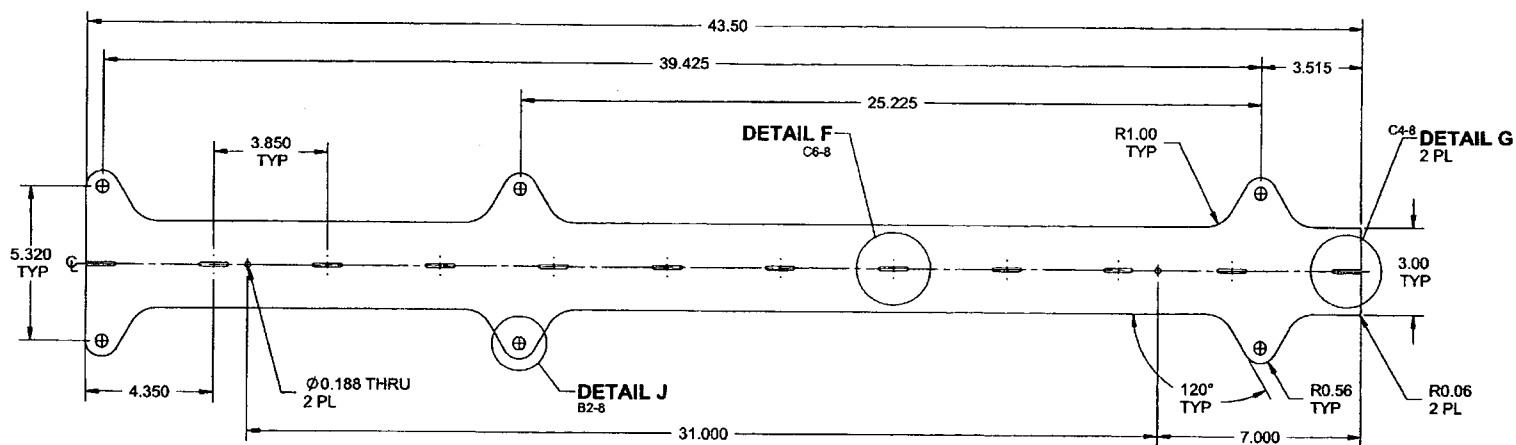




8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

RELEASED
2011-10-03

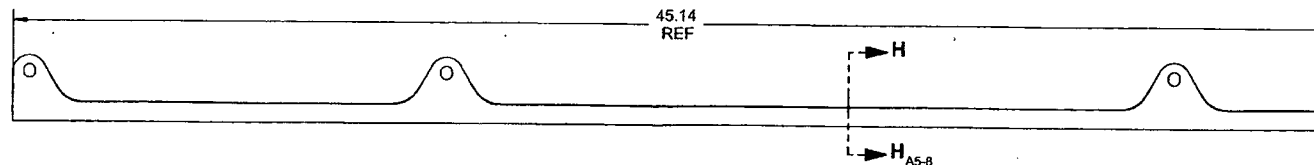
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

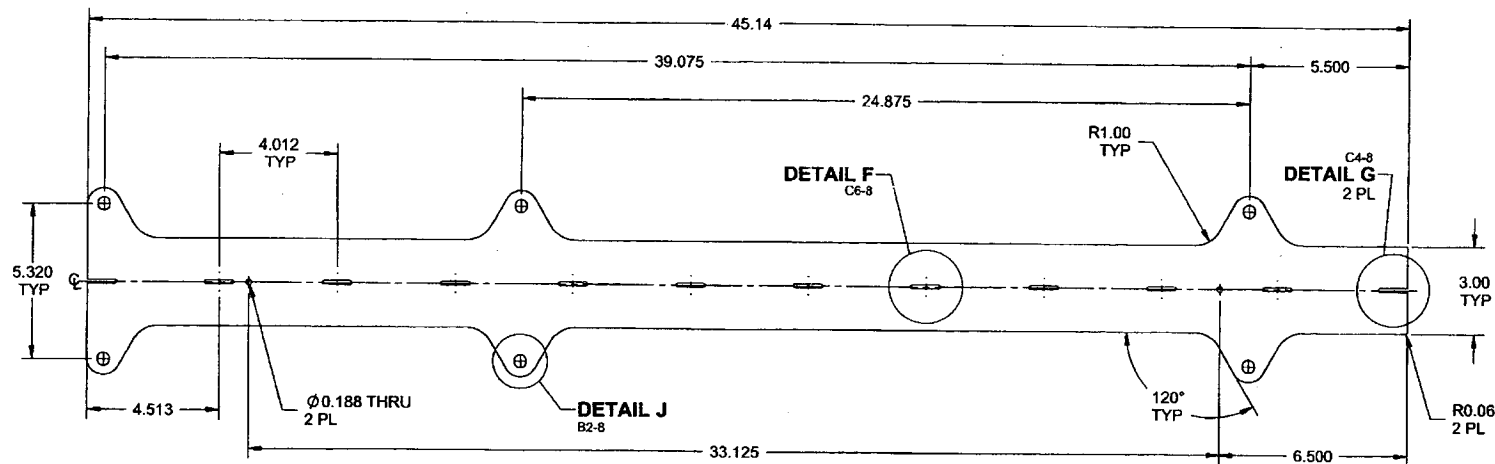
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

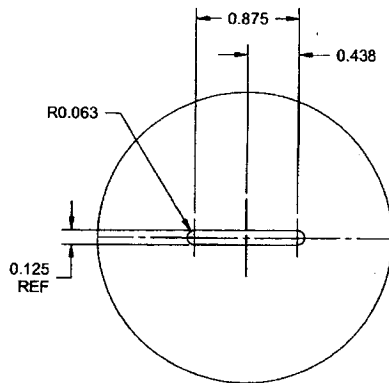
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NOTES:

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18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

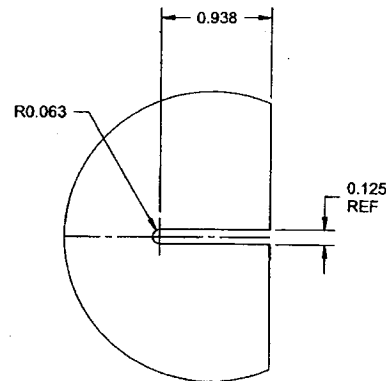
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CHECKED		DRAWING NO.	REV. B
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8 7 6 5 4 3 2 1



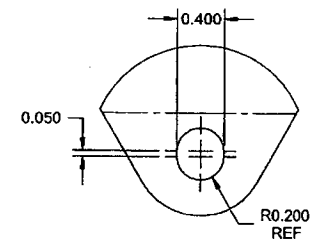
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



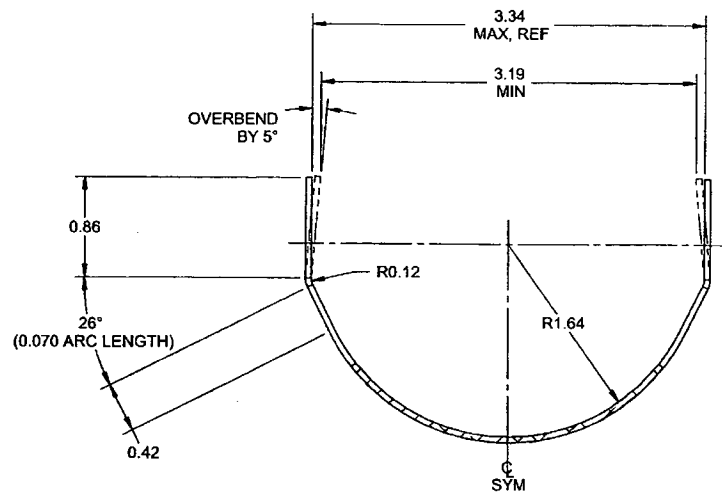
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X



B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

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R 2011-10-03

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